

Date: Tuesday, 3/20/2007 12:03:59 PM
User: Kim Johnston

Process Sheet

Split *01-04-20*

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP LEG		
Job Number	31339C						
Estimate Number	10382						
P.O. Number	<i>N/A</i>			Part Number	: D30655		
This Issue	3/20/2007 S.O. No. <i>N/A</i>			Drawing Number	: D3065 REV. B		
Prsh Rev.	NC			Project Number	: N/A		
First Issue	<i>N/A</i>			Drawing Revision	: B		
Previous Run	30466C			Material	<i>N/A</i>		
Written By	<i>JL</i>			Due Date	: 4/10/2007		
Checked & Approved By	<i>JL 07.03.20</i>			Qty:	120		
Comment	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF			Um:	Each		
	Est Rev:D Now on Water Jet 06-04-11 JLM						
	Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 1.1338 sf(s)/Unit Total : 136.0548 sf(s) <i>m 103755 x 25 28.345</i> Material: 6061-T6 0.080" thick (M6061T6S.080)	
		Batch: <i>m 103961 107.711</i> <i>mL 07 04 1B</i>	<i>120</i>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D Dwg Rev: <i>B</i> Prog Rev: <i>B</i>	<i>120</i>
		<i>mL 07 04 1B</i>	<i>120</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<i>mL 07 04 1B</i>	<i>120</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
			<i>120</i>
		Comment: SECOND CHECK	<i>120</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		<i>120</i>	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack	<i>120</i>
			<i>94</i>
		<i>-MF 07-04-23</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: E1 Date: 0104/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 12:03:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 31339C

Part Number: D30655

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/04/23

94

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(94X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML

07/04/24

94

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

MF

07-04-24

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A

MF 07-04-24

94

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(94)

Comment: FINAL INSPECTION/W/O RELEASE

SD 07/04/25

94

Job Completion



U 07-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	3133AC
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

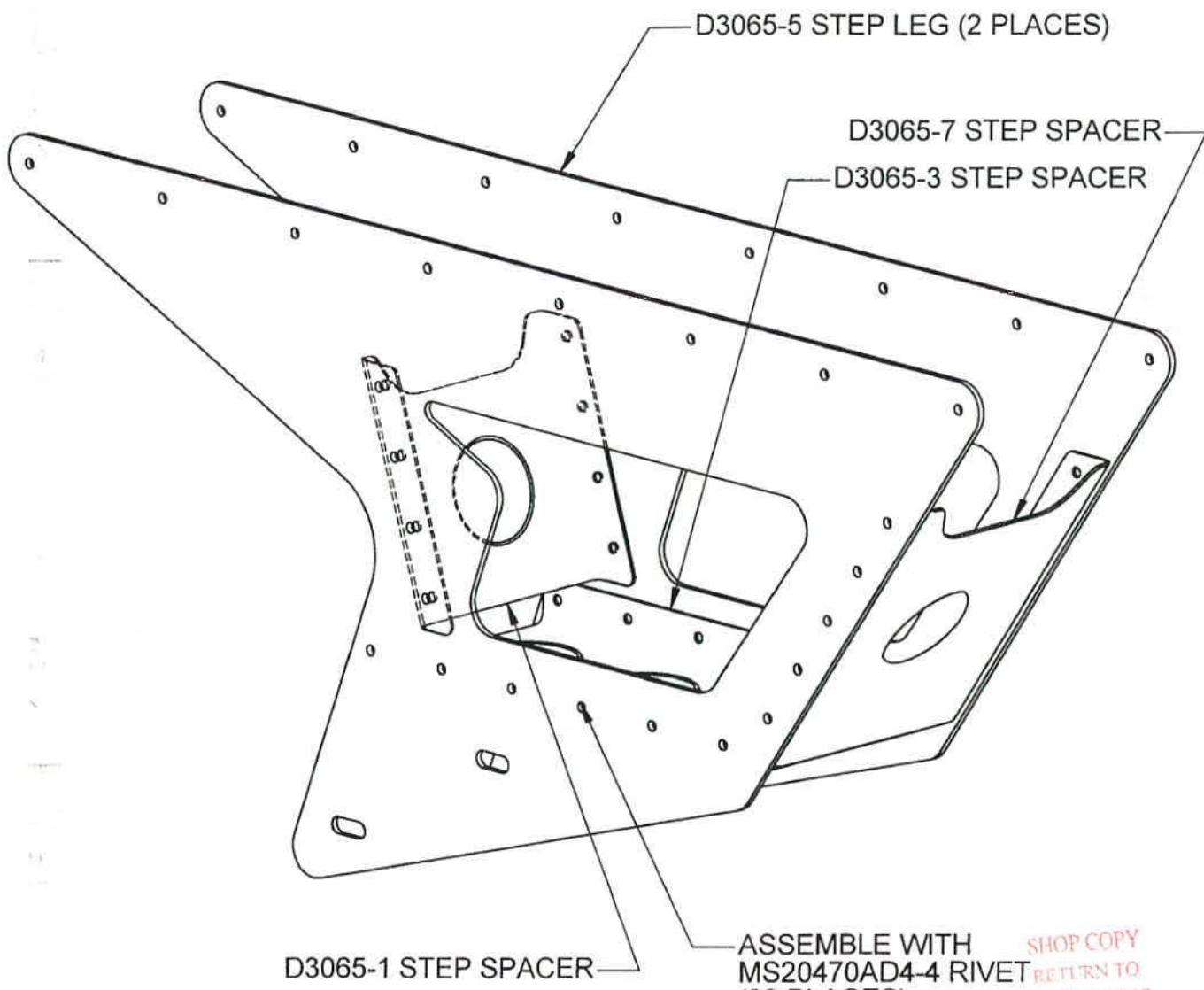
Measured by:	<u>ML, MM</u>	Audited by:	<u>DL</u>	Prototype Approval:	N/A
Date:	<u>07/04/18</u>	Date:	<u>07/04/18</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

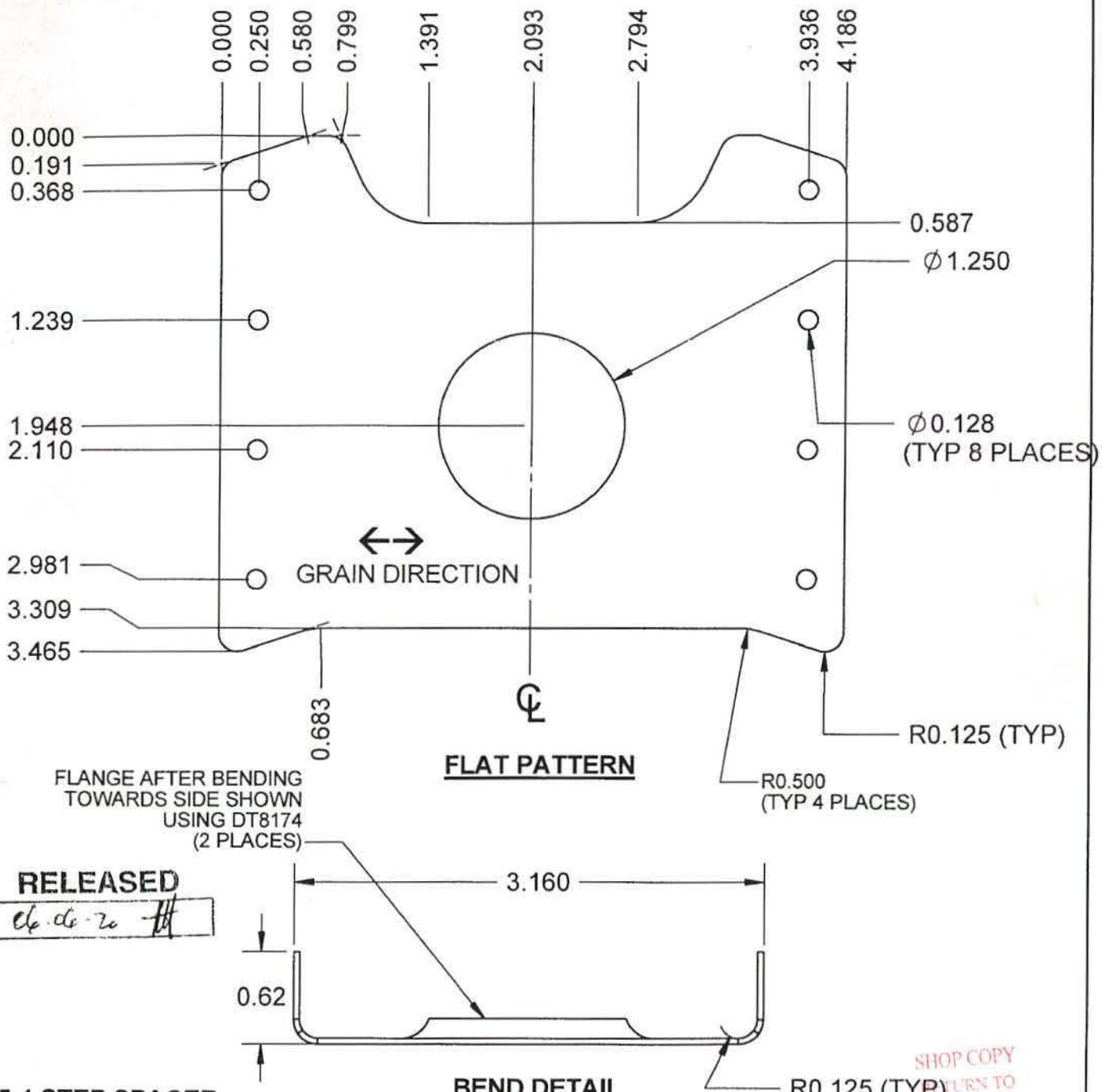
06.06.20 [Signature]**D3065-041 STEP LEG ASSEMBLY**

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CHECKED <i>PH</i>	APPROVED <i>MH</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

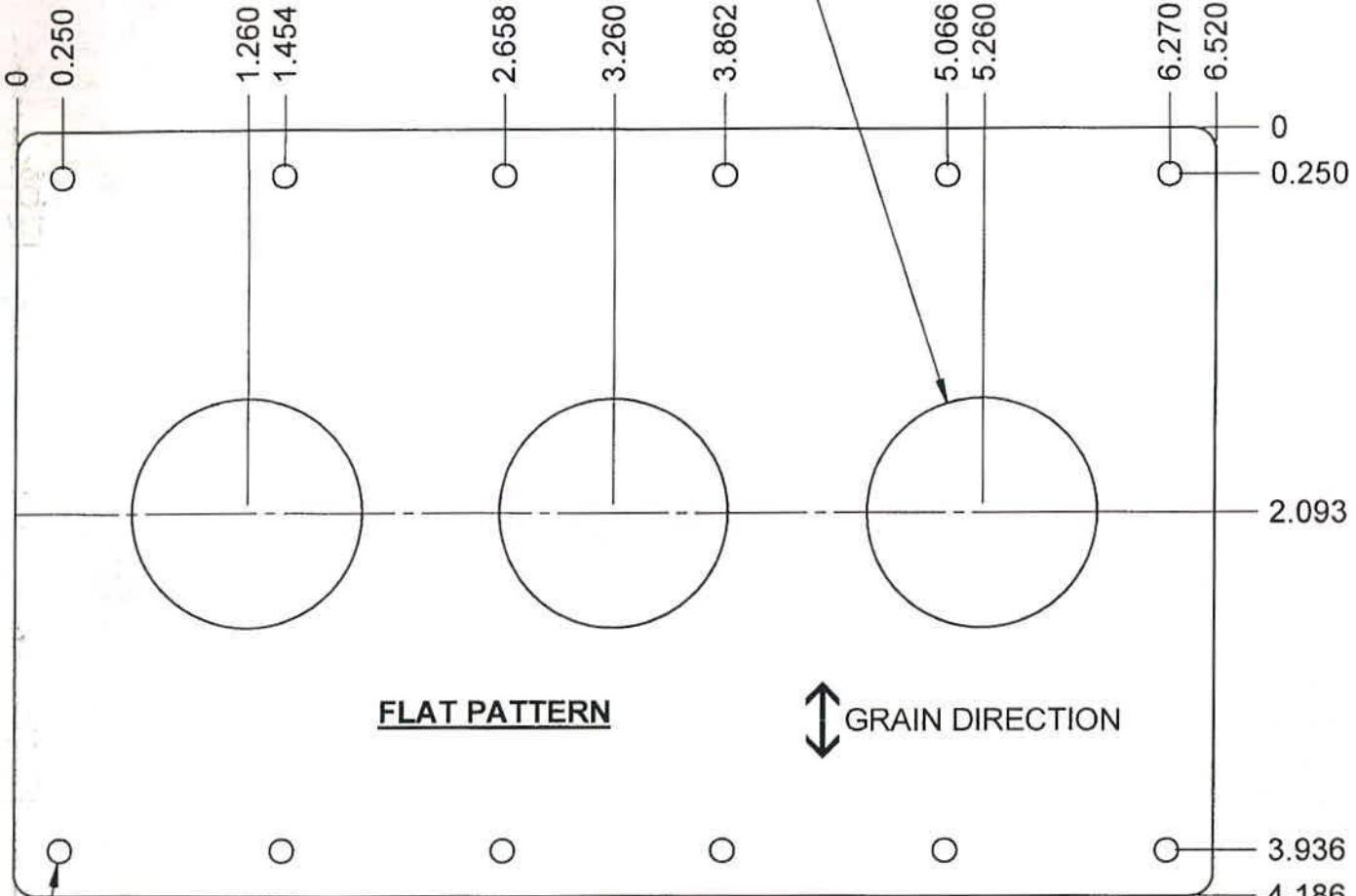
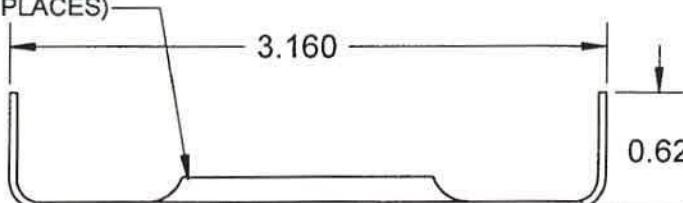
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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

 $\phi 1.250$ (TYP, 3 PLACES) $\phi 0.129$ (TYP, 12 PLACES)RELEASED
6/20 - MM**BEND DETAIL**

R0.125

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D3065-3 STEP SPACER

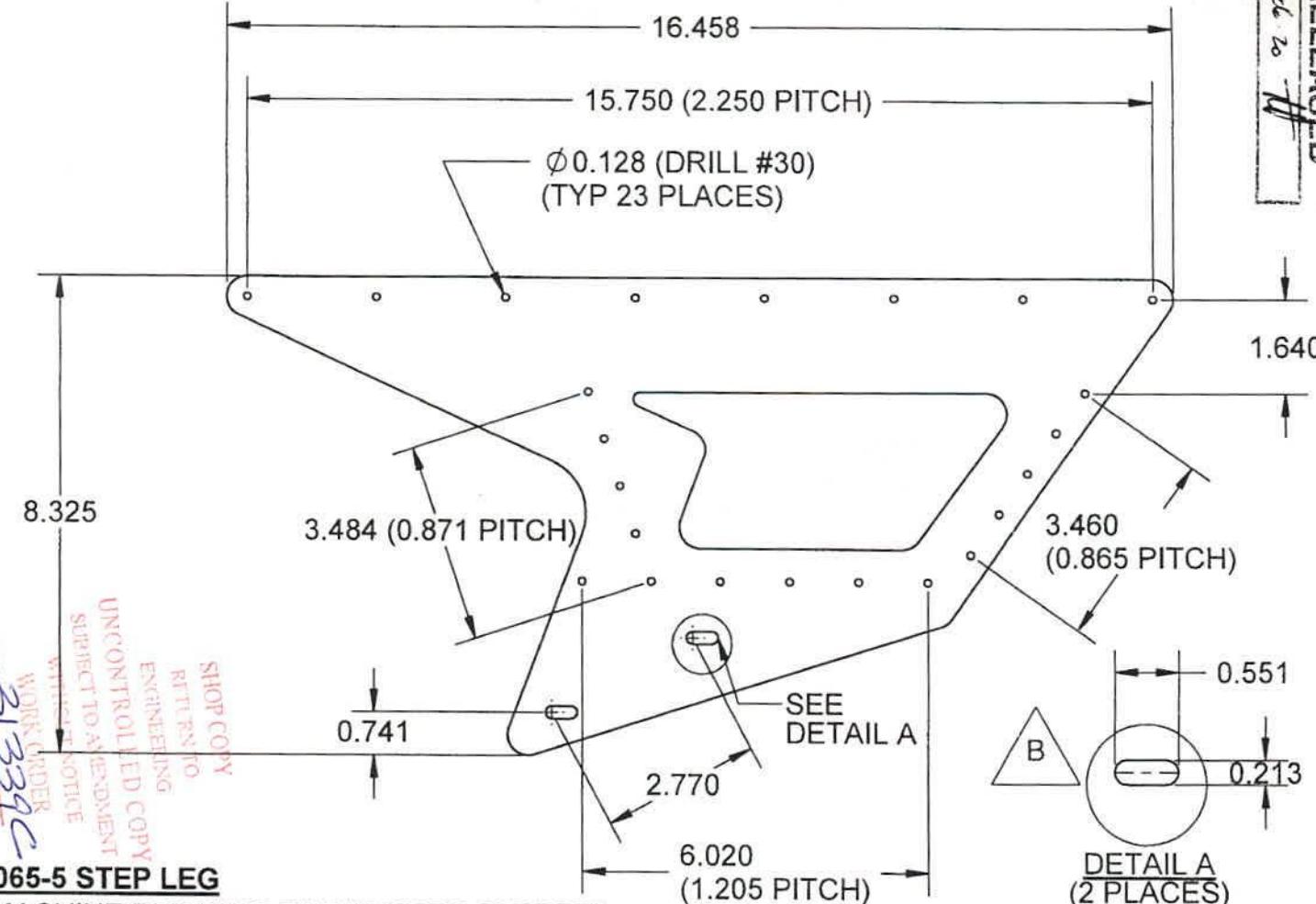
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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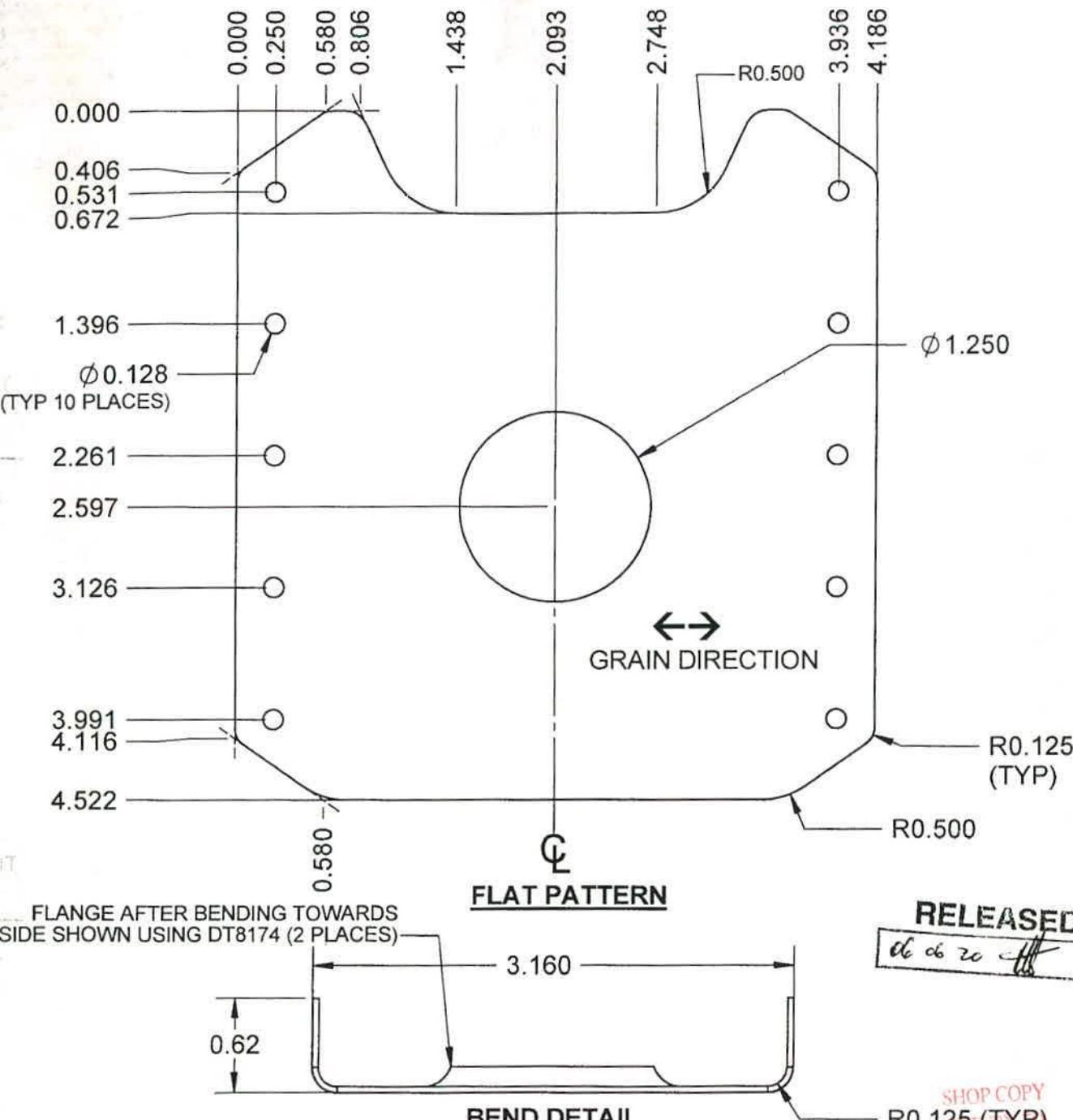
DESIGN <i>1P</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>P.H.</i>	APPROVED <i>M.H.</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 4 OF 5 SCALE 1:3

RELEASED
06.06.20**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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